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D4634-141
Job Sheet 196992



Part No: D4634-141

Job Qty: 1 pcs

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/26/19

Job Tracking No:

Due Date: 7/30/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/30/19		0.00	1.67	Small Fab - 1		SMB 19/7/18
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	7/30/19		0.00	0.00	QC 5 - 10		DAS 40 JUL 25 2019-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	7/30/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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Part Op 100 - Small Fab (Small Fab) Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: m138715 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 5139491 Expiry Date 02/01/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138960
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	100-Small Fab - 1	5135570
D4634-1	Fwd, Center Ceiling Panel	1 pcs (1 ea)	100-Small Fab - 1	5131079
D4636-5	Bracket	1 pcs (1 ea)	100-Small Fab - 1	5033715
D4647-5	Doubler	1 pcs (1 ea)	100-Small Fab - 1	5122162
D4664-5	Spacer	6 pcs (6 ea)	100-Small Fab - 1	5132128
D4712-1	Bracket	1 pcs (1 ea)	100-Small Fab - 1	5033882
D4732-15	Label	1 pcs (1 ea)	100-Small Fab - 1	5104125
D4732-19	Label	1 pcs (1 ea)	100-Small Fab - 1	5008993
D5021-1	Foam, Center Panel, Fwd	1 pcs (1 ea)	100-Small Fab - 1	5123618
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	100-Small Fab - 1	5033762
MS20426AD4-6	Rivet	2 Ea (2 ea)	100-Small Fab - 1	5093082
MS21059L08	Nut	2 Ea (2 ea)	100-Small Fab - 1	5140391

ST301
fg254
ST108
mfc05
"
mfc05
"
fg254
ST510
ST311
ST300

518035

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-03	4	190	0
	D4634-1	1	3	0
	D4636-5	1	44	0
	D4647-5	1	15	0
	D4664-5	6	25	0
	D4712-1	1	4	0
	D4732-15	1	5	0
	D4732-19	1	12	0
	D5021-1	1	1	0
	MPNY-750S-9-C	7	127	0
	MS20426AD4-6	2	957	0
	MS21059L08	2	156	0
Part Specifications				
Specifications could not be found.				

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